

# Work Order ID 71154

Thursday, August 25, 2011 11:21:27 AM

Aug 30th



DUPLICATE

Item ID:	D3262-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Canister Assembly					
Start Date:	6/23/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	7/12/2011	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-08-25</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3262	E

100	Weld per dwg A/R Aluminum rod Batch <u>1117884</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld canister assembly as per Dwg D3262 using DT8739 to align fittings								

1 8 BE 7/28/24

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

11-08-31

1 0

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Pressure test as per Dwg D3262								

8 11/09/01

(40)

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Page 2

Item ID:	D3262-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Canister Assembly					
Start Date:	6/23/2011	Start Qty:	2.00			
Required Date:	7/12/2011	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Chemical Conversion Coat per QSI005 4.1	0.00				1	BR	11-9-1.	
	HandFinish	0.00							
	Hand Finishing								

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
	Powder Coating								

M117745

Memo

\*\*\*\*Ensure to mask threads \*\*\*\*

START TIME: 10:50

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:20

150	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Quality Control								

IX Ø M/L 11/09/01

1 Ø M/L 11/09/01

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Page 3

Item ID: D3262-043

Accept

Revision ID:

Item Name: Canister Assembly

Start Date: 6/23/2011 Start Qty: 2.00

Required Date: 7/12/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

PPP 70609

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Thursday, August 25, 2011 11:21:22 AM

Page 1

Work Order ID: 71154

Parent Item: D3262-043

Parent Item Name: Canister Assembly



Start Date: 6/23/2011

Required Date: 7/12/2011


Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.01.19 new issue EC verified by: DD  
as per ECN10-571 DD 10.05.10 verified :EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3262-1  Tube		Manufactured	No			100	Each	1.0000	1	2			
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Location	Loc Qty	Loc Code
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LG002	1	
70738	1	

D3262-5  Cap		Manufactured	No			100	Each	4.0000	2	4			
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Location	Loc Qty	Loc Code
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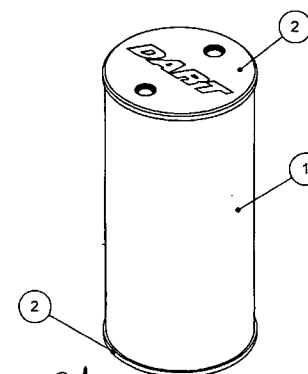
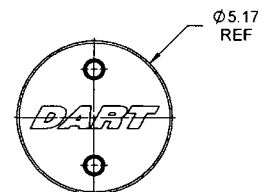
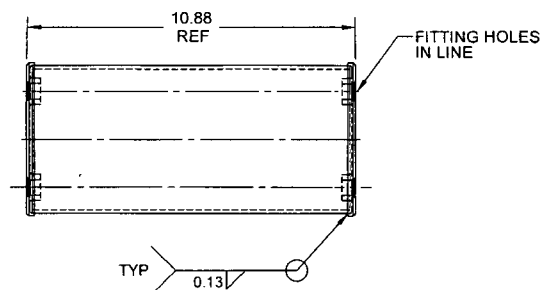
LG002	4	
70897	4	

BEU/08/29

BEU/08/29

2

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



# **D3262-041 CANISTER ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

E	0.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5); ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043/-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.05.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

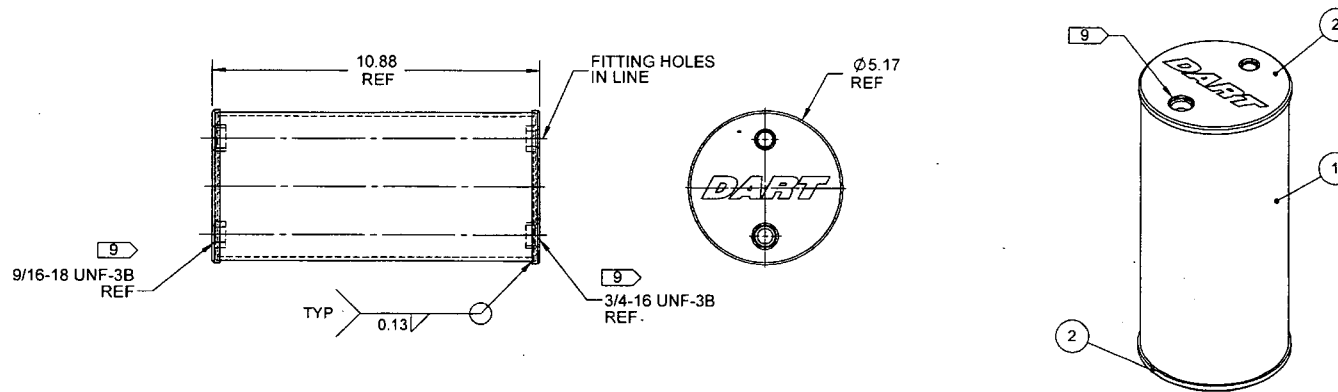
DRAWING NO. **D3262** REV. E  
SHEET 1 OF 5  
TITLE **FUEL PURGE CANISTER** SCALE NTS

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2010-05-07

# 71154

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP



**D3262-043 CANISTER ASSEMBLY**

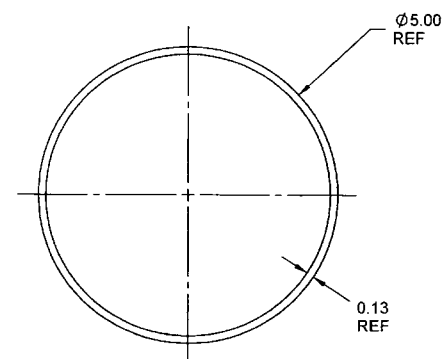
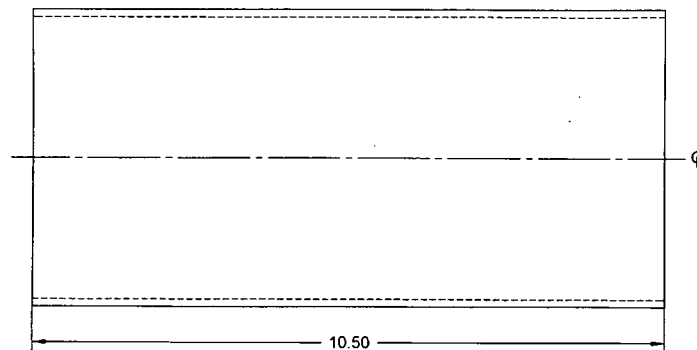
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR  
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D3262</b>	REV. E
MFG. APPR.	RF	SHEET 2 OF 5	
APPROVED	RF	TITLE <b>FUEL PURGE CANISTER</b>	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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**D3262-1 TUBE**

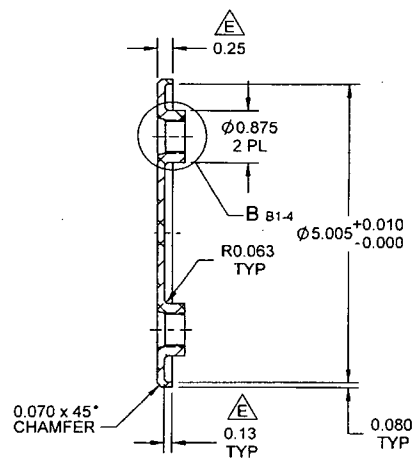
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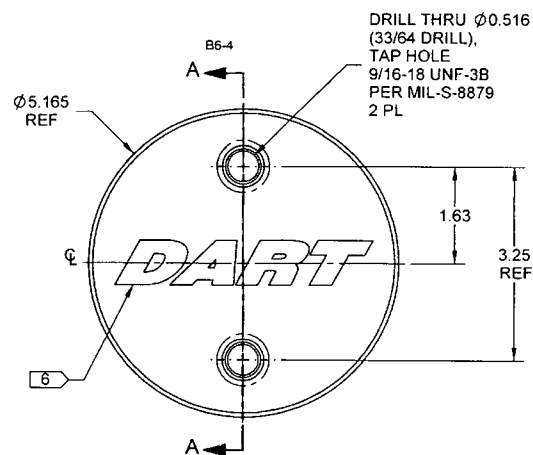
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

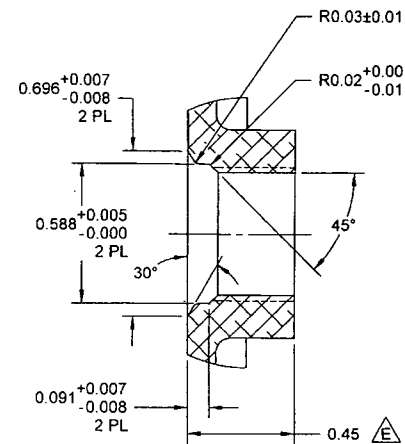
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3262</b>	REV. E
MFG. APPR.	RF	SHEET 3 OF 5	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>FUEL PURGE CANISTER</b>	NTS
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**SECTION A-A** C5-4



**D3262-3 CAP**



**DETAIL B** C7-4  
SCALE 2X

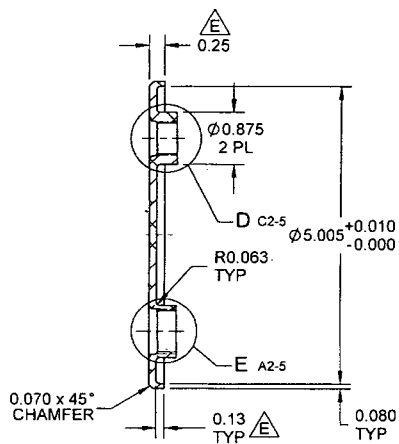
**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

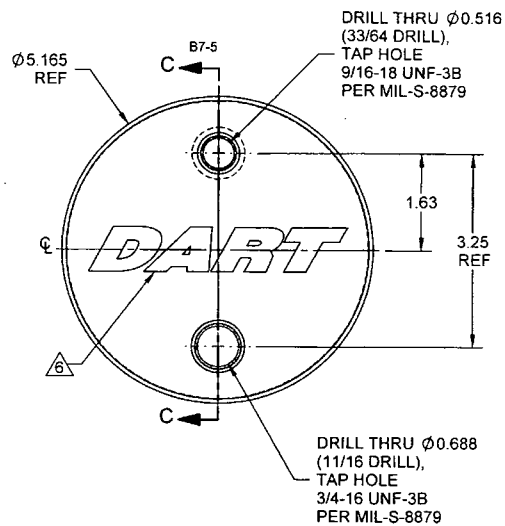
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3262	SHEET 4 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	FUEL PURGE CANISTER	NTS
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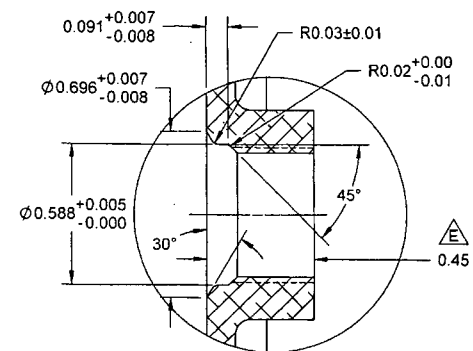
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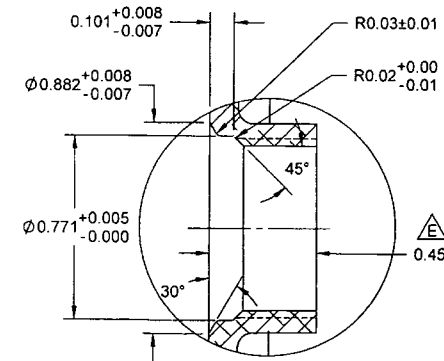
**SECTION C-C** D5-5



**D3262-5 CAP**



**DETAIL D** C7-5  
SCALE 2X



**DETAIL E** B7-5  
SCALE 2X

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR  
PER QQ-A-200/8 OR QQ-A-225/8  
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>RF</i>	<b>D3262</b>	SHEET 5 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>FUEL PURGE CANISTER</b>	NTS
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